

Split-2 *[Signature]* *[Signature]* *Mar 2*
Work Order ID 114454

March-05-14 1:06:50 PM

114454

Page 1

Item ID: D3414-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 3/05/14 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 3/10/14 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3414	Rev C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3414-1

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

16 0 Jm 14-03-26

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

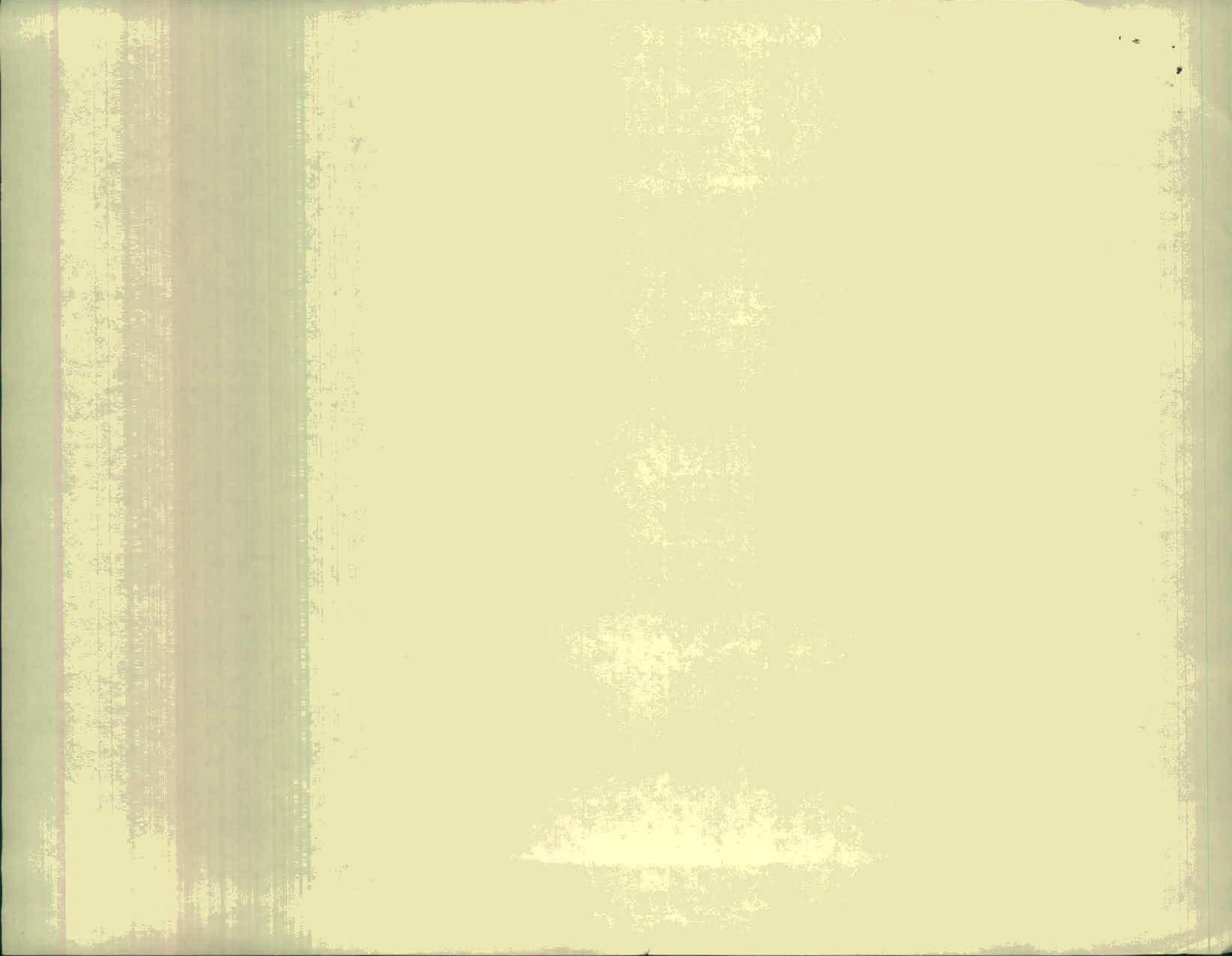
QC

Quality Control

Memo

0.00

16 0 Jm 14-03-26



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Page 2

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Revision ID:

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Item Name: Lug

Start Date: 3/05/14

Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/10/14

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

130

Brake NC

Brake NC

Memo

1-Debur

2-Form using DT8254 as per Dwg D3414

0.00

0.00

DAS
30
9-89

140

140

Large Fab

Large Fab

Memo

1- Weld using location Jig DT9625 as per Dwg D3414

A/R S.S. welding rod Batch: M100854

0.00

0.00

16 14-5-5

14/03/26

split.

30
00

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114454

Page 3

Item ID: D3414-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 3/05/14 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 3/10/14 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per OSI004- Fusion Welds	0.00							DAS 9 9-89
150						(16)	14-05-05		
QC	Memo	0.00							
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
160						(16)	14-05-05		
QC	Memo	0.00							
Quality Control									
175		0.00							DAS 04 9-89
175						16	14-5-8		
Spray Paint									
Spray Painting									

powder coat
Memo
PRIME B
DEL FLEET BLUE B
DEL FLEET CLEAR B

*white m/28024
START: 1:15
oven-T: 450°
Finish: 1:45*

680
94
Dhr

Work Order ID 114454

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114454

Page 4

Item ID: D3414-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 3/05/14 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 3/10/14 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

185

185

QC

Quality Control

QC1- Inspect Spray Paint
Memo

0.00

0.00

190

190

Packaging

Packaging

Identify as per dwg & Stock Location ST471

Memo

0.00

0.00

200

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

160X 14-5-9 DAS 26 9-89

ML9 14-05-12
H 14-05-12

Picklist Print

March-05-14 1:06:50 PM

Page 1

Work Order ID: 114454

114454

Parent Item: D3414-041

D3414-041

Parent Item Name: Lug

Start Date: 3/05/14

Required Date: 3/10/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S12GA

Purchased

No

100

sf

118.6300

0.155

1

M304S12GA

jm 14-03-26

304/316 0.100" Sheet

Location

Loc Qty

Loc Code

MAT019

118.63

113062

76.13

113077

19

m126309

23.5

126309.

D3414-3

Manufactured

No

140

Each

48.0000

1

5

D3414-3

R 14-5-5

Lug

Location

Loc Qty

Loc Code

WA001

48

106695

8

111462

40

114975x 16

DART AEROSPACE LTD		Work Order: 114454
Description: Lug Bracket		Part Number: D3414-1
Inspection Dwg: D3414	Rev: C	Page 1 of 1

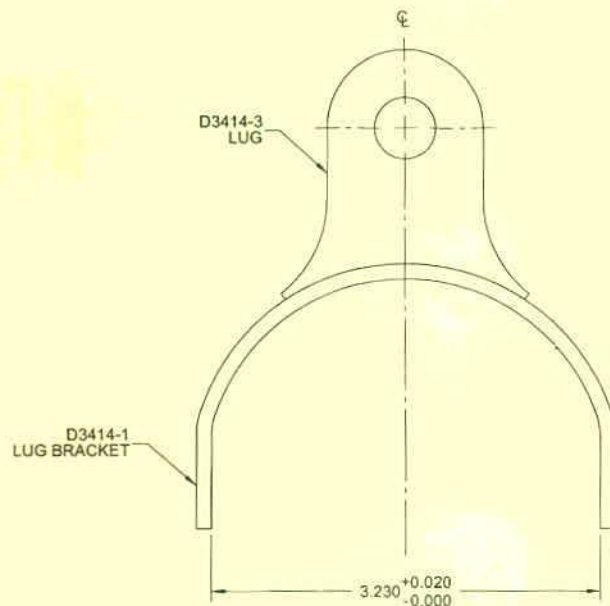
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

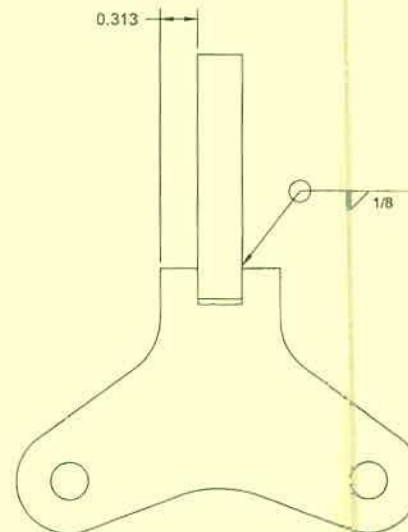
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	0.316"	-		U	Jlmo 5
1.19	+/-0.030	1.19"	-		U	
1.00	+/-0.030	1.010"	-		U	
3.38	+/-0.030	3.386"	-		U	
5.350	+/-0.010	5.353"	-		U	
6.23	+/-0.030	6.237"	-		U	
2.500	+/-0.010	2.503"	-		U	
0.37	+/-0.030	0.376"	-		U	
0.100	+/-0.010	0.102"	-		U	

Measured by: Jm	Audited by: DAS 27 3-89	Prototype Approval: N/A
Date: 14-05-26	Date: 14/3/26	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	

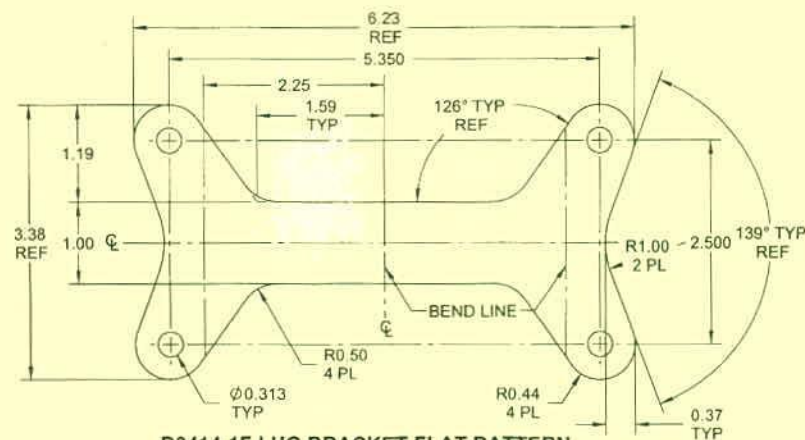


D3414-041 LUG ASSEMBLY

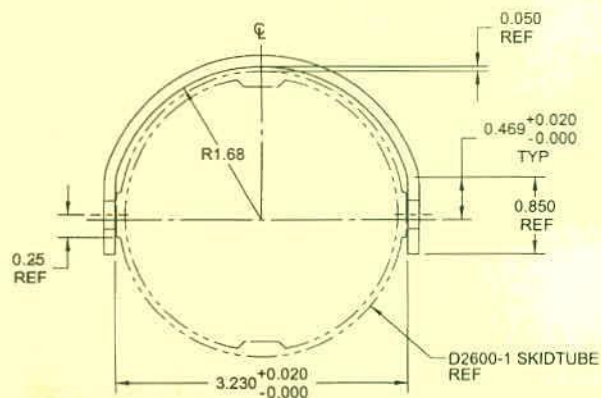


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09/06/17

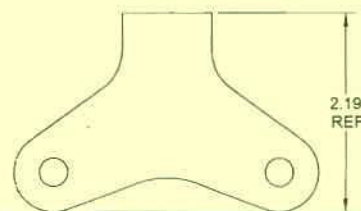
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3414	SHEET 2 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
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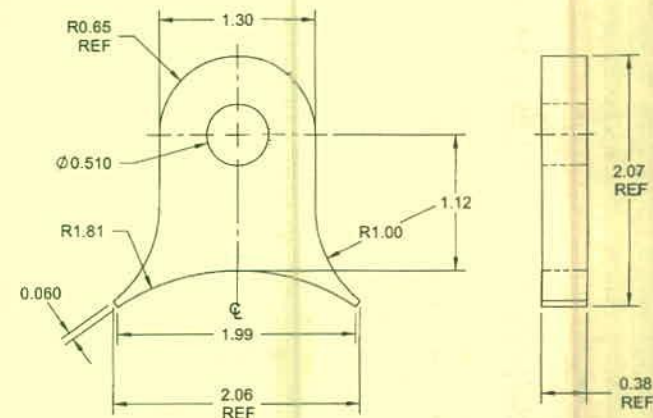
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES:
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A
7) WEIGHT: N/A

RELEASED

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